

148238

Tuesday, June 28, 2016 8:56:39 AM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

20

Start Date: 6/16/2016 **Start Qty:** 10.00 ***10***

Cust Item ID:

Required Date: 6/27/2016 **Req'd Qty:** ~~10.00~~ ***10***

Customer:

Reference:

DAS

Approvals: Process Plan: 21 Date: JUL 04 2016
0.89

Tooling:

Date:

Run Start *NR1*

QC: _____

Date: _____ **SPC (Y/N):** _____

Date:

Stop ***NR2***

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Work Order ID 148238

Tuesday, June 28, 2016 8:56:39 AM

148238

Page 2

Item ID: D1049 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle
 Start Date: 6/16/2016 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 6/27/2016 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							DAS 44 9-89
130						20	0		16-07-20
QC	Memo	0.03							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							DAS 34 9-89
140						20			2016/07/21
HandFinish	Memo	0.03							BEB
Hand Finishing									
150	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							23 34 99
150						20	0		160725
Powdercoat	Memo	0.02							
Powder Coating	START TIME: 1:40 OVEN TEMPERATURE: 320° FINISH TIME: 2:10								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

DQA: _____ Date: _____

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Work Order update only ☐

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OTHER : ☐									

Picklist Print

Tuesday, June 28, 2016 8:56:38 AM

Work Order ID: 148238

148238

Parent Item: D1049

D1049

Parent Item Name: Saddle

Start Date: 6/16/2016

Required Date: 6/27/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP RevC02.04.10Re-formatNG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B0.750X00.25
0

Purchased

No

100

f

7.5990

0.1666

1.753684

3.33

M6061T6B0 750X00 250

6061-T6 Bar .750 x .250

**

3.700

DAS
20
9-89 16-07-17

Location

Loc Qty

Loc Code

MAT

7.599

(m131392)

7.599

3.700

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

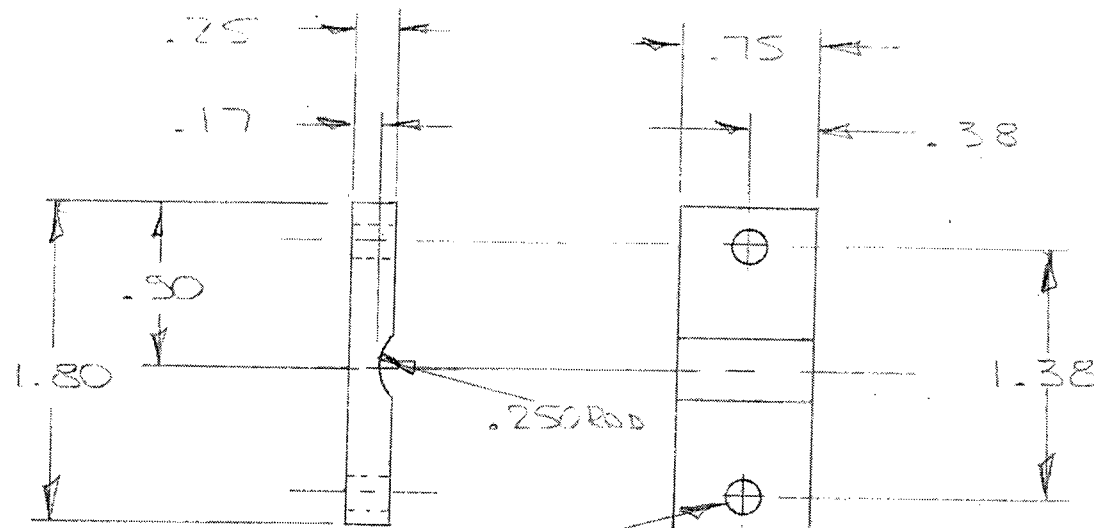
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

RELEASED
9710802 B.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 148238 MJS
16-07-04



.203 DIA.
TYP

MATERIAL : 5052-H32

FINISH : POWDER COAT



REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
DRAWN			BASIC CODE	DA, DASH NO. H-HEAD MEAT SIDE F-HEAD FAN SIDE	CONTRACT NO.		DART DART AERO ACCESSORIES INC. VANCOUVER CANADA		
APPROVED			W-DIMPLE DIGIT-NO OF SHEETS C-COUNTERSINK	LENGTH DASH NO. W-SPOTWELD	DRAWN	DATE			
DESCRIPTION OF CHANGE	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED		BASIC CODES		DESIGN	1982	TITLE SADDLE		
	GENERAL	LIMITS	BASIC CODES B-MASTICATION BB-MAS 20476AD		STRESS		CODE		
	1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125-4 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER MIL - S - 7142 5. HOLES PER AND 10387	1. TOLERANCES — JOK & .030 2. ANGLES XXX & .010 3. PARALLELISM .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL MAX CENTRE LINES .005	CHECKED		DWG NO D1049			REV	
REPORT ALL DISCREPANCIES — DO NOT SCALE									